



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9711
Job Sheet 165558



Part No: 646.9711

Job Qty: 25 ea

Part Name: Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV D2 SHEET 5 IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
646.9711 Blade	DWG REV D2 SHEET 5 IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD		0.000	
MSTEEL-A2-B0.500X1.250 AISI A2 Tool Steel Bar, 0.500 X 1.250			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	25 Ea	10/28/17	0.00	0.00	Start up container	
100	Bandsaw	25 pcs	10/28/17	0.00	0.78	Bandsaw1	
110	CNC Vertical Machining	25 pcs	10/31/17	0.13	19.90	HAAS 1	<i>marg 17/11/14 / JF</i>
120	QC	25 pcs	10/31/17	0.00	0.00	QC2	<i>marg 17/11/14 / JF</i>
130	QC	25 pcs	10/31/17	0.00	0.00	QC8	<i>FK 17-11-15</i>
140	Outsource	25 pcs	10/31/17	0.00	0.00	Outsource1	<i>SP 17-12-4</i>
150	Packaging	25 pcs	10/31/17	0.00	0.00	Packaging2	<i>SP 17-12-4</i>
155	QC	25 pcs	10/31/17	0.00	0.00	QC5	<i>38</i>
160	Spray Paint	25 pcs	10/31/17	0.00	0.46	Spray Paint	<i>DE 17-12-06</i>
170	QC	25 pcs	10/31/17	0.00	0.00	QC14	<i>38</i>
180	Packaging	25 pcs	10/31/17	0.00	0.00	Packaging3	<i>CEL 106</i>
190	QC21-SA	25 Ea	10/31/17	0.00	0.00	QC21	<i>21</i>

Part Op 100 - Cut Blank at 4.625"

Descriptions: 110 - 1-Machine per folio FB135

140 - HEAT TREAT AS PER DWG, SEE NOTE #3

160 - ***THIN COAT OF PRIMER*** PRIME AS PER DWG, SEE NOTE #4

Prime Batch 138374

NOV 22 2017

P/O: 38454

DEC 07 2017
DAS
13
9-20

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MSTEEL-A2-B0.500X1.250	10	0	0	0
<i>M138361 (5007000) (5007000) 5007000 ??</i>					

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S009231

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Blade

PART NO: 646.9711

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/13/17

Job No: 165558

Work Order ID 165558

Monday, August 28, 2017 11:40:20 AM

165558

Page 1

Item ID: 646.9711 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blade
Start Date: 9/19/2017 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 10/13/2017 Req'd Qty: 25.00 ***25*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: **AUG 29 2017** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.9700	D2

100		0.00
100	BAND SAW	
Bandsaw	Memo	0.81
Jeaspa Bandsaw	Cut Blank at 4.625"	

25 ϕ *AMM*
17/11/14

110		1.86
110	HAAS CNC VERTICAL MACHINING #1	
HAAS I	Memo	3.83
HAAS CNC vertical machine #1	1-Machine per folio FB135	
	DWG REV: <u>D2</u>	
	FOLIO REV: <u>P</u>	

25 ϕ *AMM*
17/11/14

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

Work Order ID 165558

Monday, August 28, 2017 11:40:20 AM

165558

Page 2

Item ID: 646.9711

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blade

Start Date: 9/19/2017 Start Qty: 25.00

25

Cust Item ID:

Required Date: 10/13/2017 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						25	Ø		
QC	Memo	0.25							
Quality Control									mm L 17/11/15
130	QC8- Inspect parts - second check	0.00							
130						25	Ø		FR 17-11-15
QC	Memo	0.50							
Quality Control									
140	Outsource process - Heat Treat	0.00							
140									
Outsource I	Memo	6,000.00							
Outsource process - Heat Treat	HEAT TREAT AS PER DWG, SEE NOTE #3								
	ISSUE P/O: _____								

Monday, August 28, 2017 11:40:20 AM

Page 4

[illegible]

Picklist Print

Page 1

Monday, August 28, 2017 11:40:25 AM

Work Order ID: 165558

165558

Parent Item: 646.9711

646 9711

Parent Item Name: Blade

Start Date: 9/19/2017

Required Date: 10/13/2017

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased	No			100	f	31.4940	0.386	10.1579			

MSTFEI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

Location

Loc Qty

Loc Code

MAT010

31.494

M138008

7.494

M138361

24



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO.

05360

SHEET 1 OF 1

DWG NO. 646.9700

REV: D

PREPARED BY J. BECKER

DATE: 03/24/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]*

QC *[Signature]*

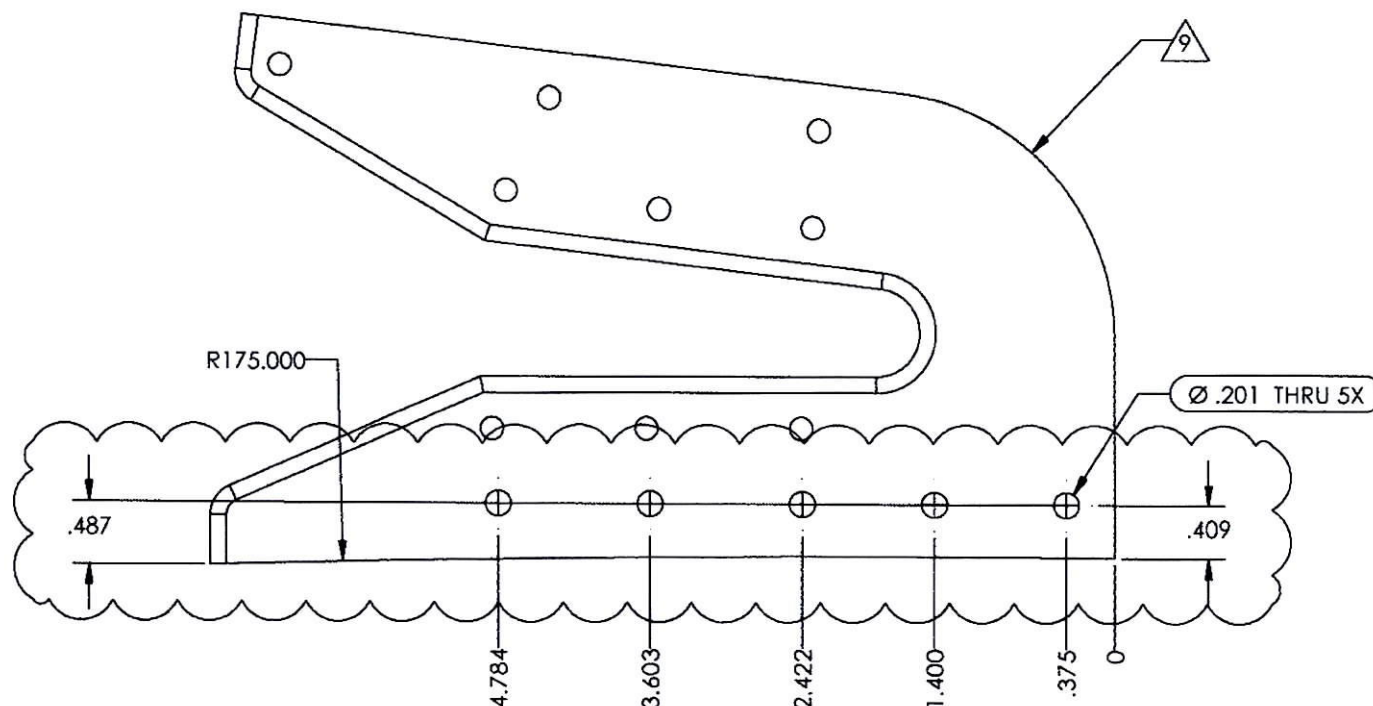
EFF. CURRENT ORDER

REASON: REVISED DIMENSIONS

ECR: N/A

ACTION ITEM:
1.

SHEET 7, ZONE C3 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165558 MC
1708-29

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

DART
AEROSPACEAPICAL INDUSTRIES, INC.
dba DART AEROSPACETRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO.

05345

SHEET 1 OF 1

DWG NO. 646.9700

REV: D

PREPARED BY J. GARDINER

DATE: 03/15/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR.

MFG

QC

EFF.

CURRENT ORDER

REASON: REVISED NOTES

ECR:

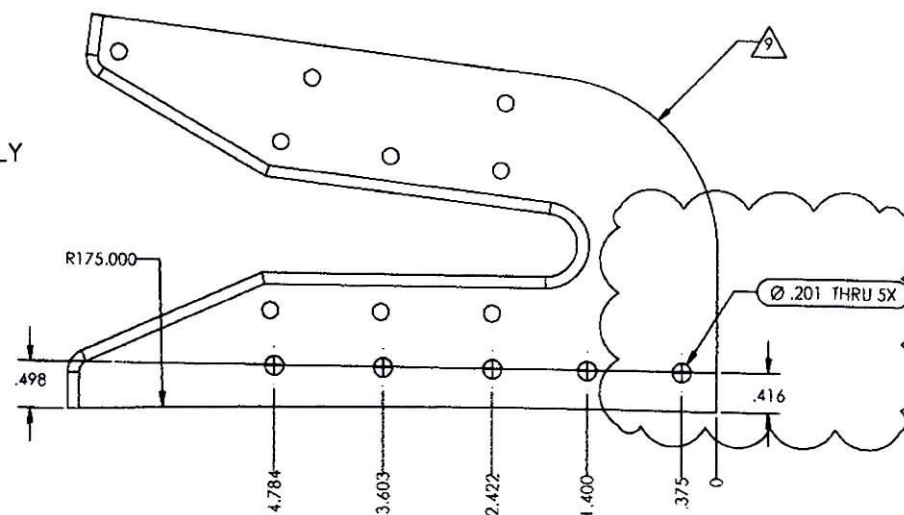
N/A

ACTION ITEM:
1.**SHEET 1, ZONE A6 IS:**

NOTES:

IS

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH IAW MPP-172 SECTION 2.1, 3.3 & 4.3.
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MPP-172 SECTION 3.3; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

SHEET 7, ZONE C5 IS:

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

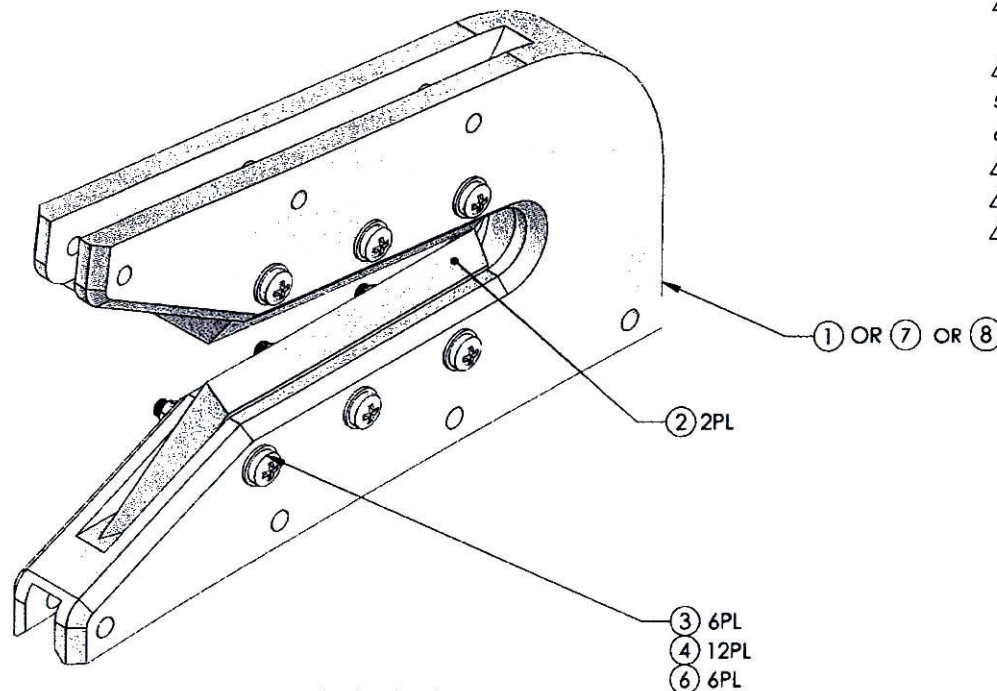
☐ YES ☒ NO

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION - P82		N/C
NC	MSA RELEASE	03/29/01	P. BRAVO
A	INCORPORATED ECN 02744 03038 03P12	04/06/03	P. BRAVO
B	INCORPORATED ECN 02847	07/03/03	P. BRAVO
C	INCORPORATED ECN 04039	08/09/03	P. BRAVO
D	INCORPORATED ECN 05329	03/28/04	P. BRAVO

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH IAW MPP-172 SECTION 3.3 & 4.3.
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MPP-172 SECTION 3.3; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



646.9701 SHOWN
646.9702 & 646.9703 TYP

UNINCORPORATED ECN(S)

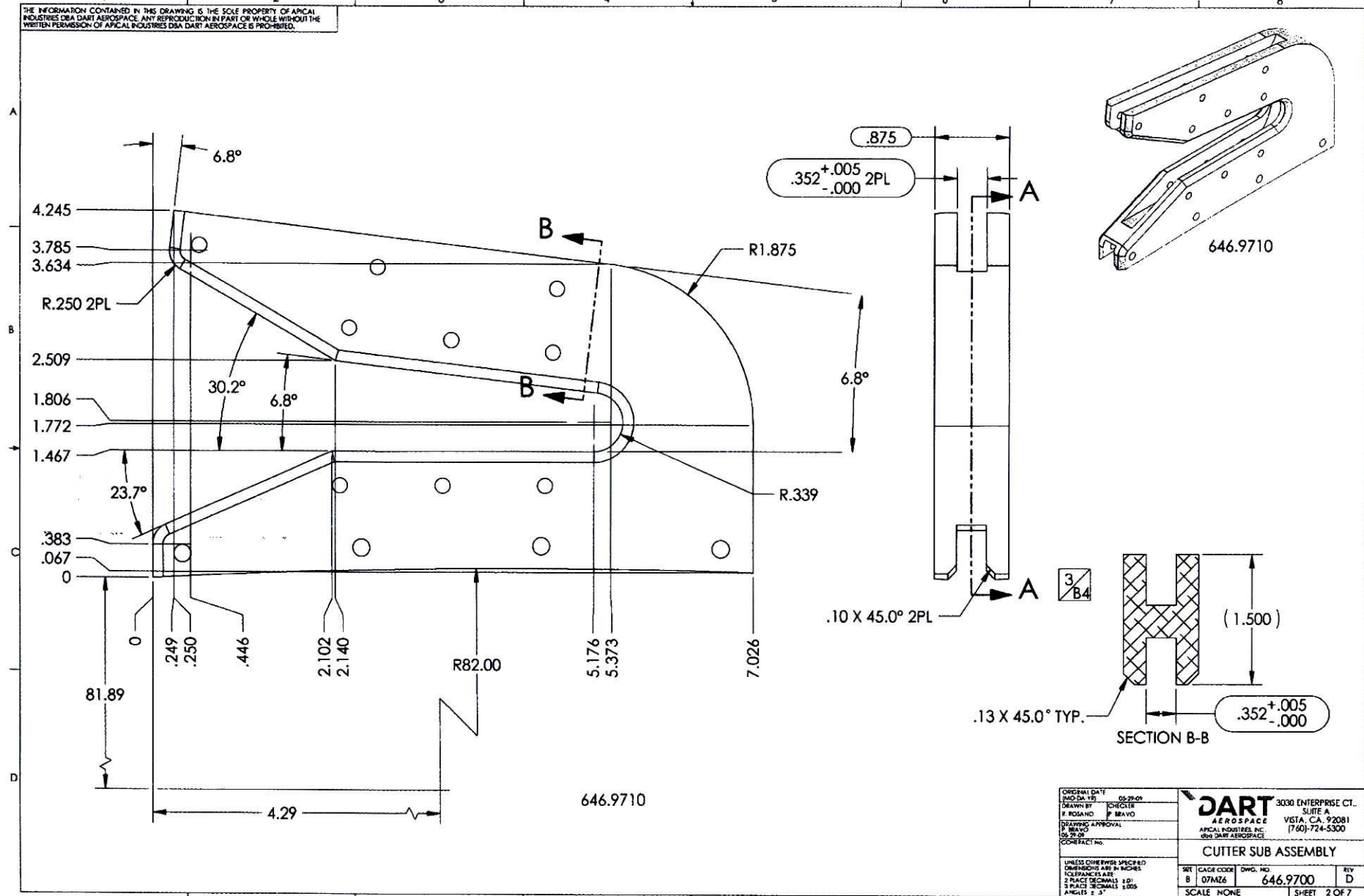
05345, 05360,

1			8	646.9713	BODY			
	1		7	646.9712	BODY			
6	6	6	6	601.1541	LOCKNUT	MS21042L08		
A/R	A/R	A/R	5	601.2045	RTV, LOCTITE 598			
12	12	12	4	601.2764	WASHER	MS3119F14B32P		
6	6	6	3	601.2765	SCREW	MS27039-0819		
2	2	2	2	646.9711	BLADE			
			1	646.9710	BODY			
X				646.9703	CUTTER SUB ASSY			
	X			646.9702	CUTTER SUB ASSY			
		X		646.9701	CUTTER SUB ASSY			
9703	9702	9701	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
QTY				PARTS LIST				
NEXT ASSY (S)				ORIGINAL DATE 03-29-01				
646.9600				DRAWN BY: CHECKER				
				P. ROSA-MO P. BRAVO				
				DRAWING APPROVAL: P. BRAVO				
				03-29-01				
				CONTRACT NO.				
				UNLESS OTHERWISE SPECIFIED				
				DIMENSIONS ARE IN INCHES				
				TOLERANCES ARE:				
				3 PLACE DECIMALS ±.01				
				ANGLES ± .5°				
				CAGI CODE: DWG NO: 646.9700				
				B. 07M26				
				SCALE: NONE				
				SHEET 1 OF 7				

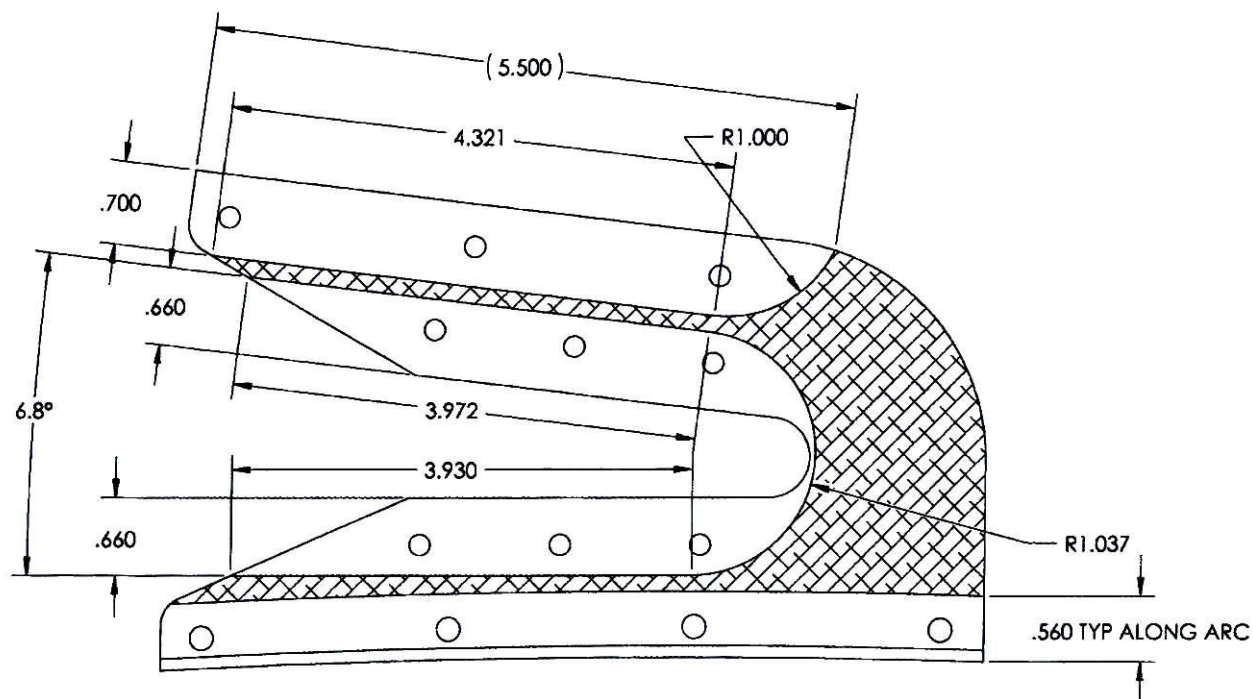
DART 3030 ENTERPRISE CT., SUITE A
AEROSPACE VISTA, CA 92081
APICAL INDUSTRIES INC. (760) 724-5300
(DBA DART AEROSPACE)

CUTTER SUB ASSEMBLY

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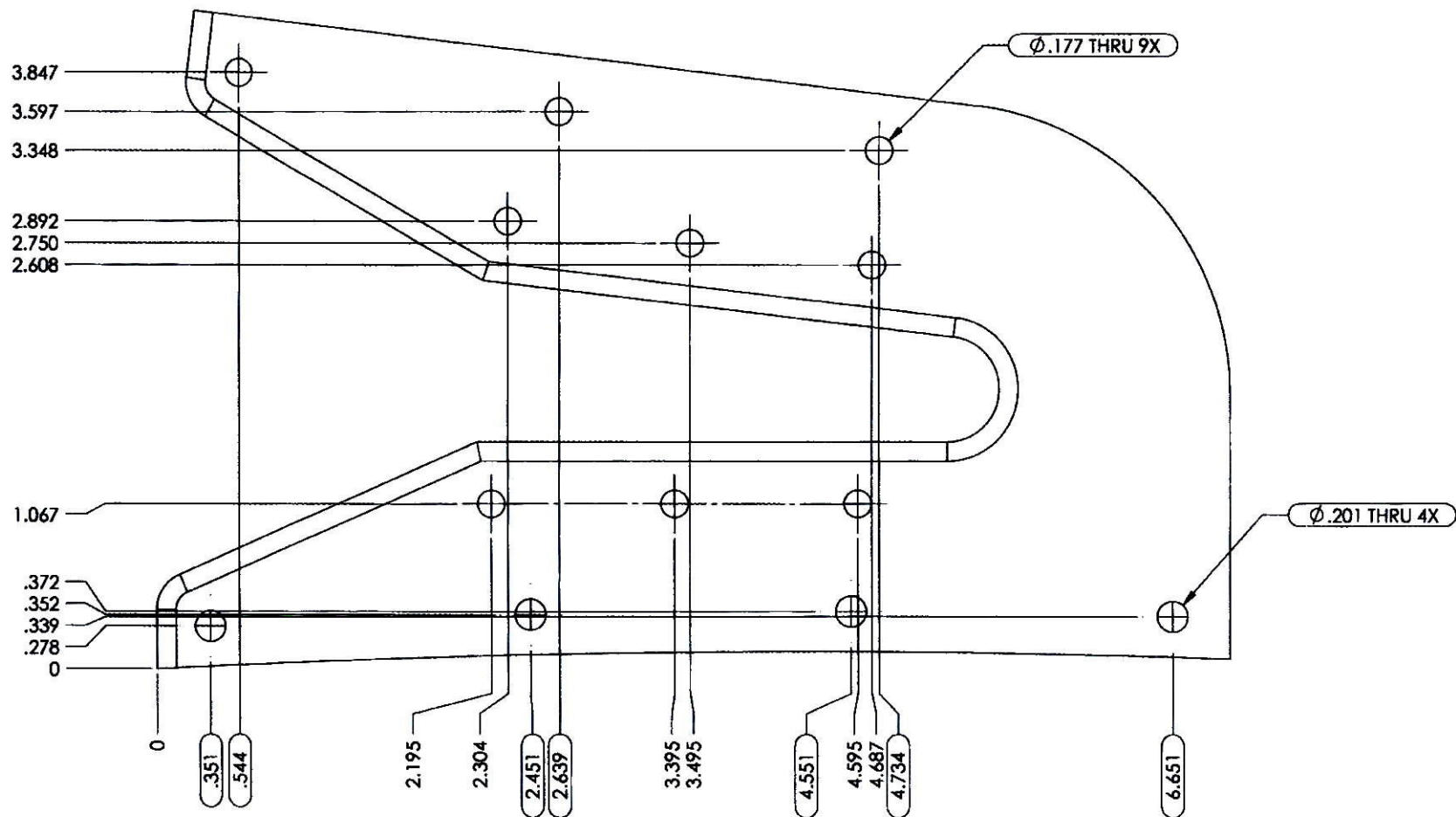


SECTION A-A 2/C6

646.9710

ORIGINAL DATE: 05/29/09		3000 ENTERPRISE CT., SUITE A	
DRAWN BY: E. ROSANO		VISTA, CA. 92081	
CHECKED BY: P. BRAVO		(760)-724-5300	
DRAWING APPROVAL: E. BRAVO		APCAL INDUSTRIES, INC. DBA DART AEROSPACE	
SCALE: NONE		CUTTER SUB ASSEMBLY	
REV: B	CAGE CODE: 07M26	DWG. NO.: 646.9700	REV: D
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: 2 PLACE DECIMALS ± .01, 3 PLACE DECIMALS ± .005, ANGLES ± .5°		SHEET 3 OF 7	

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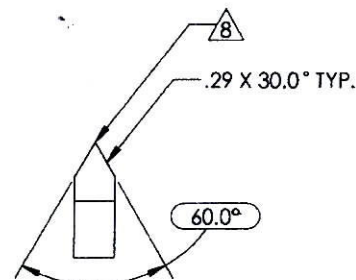
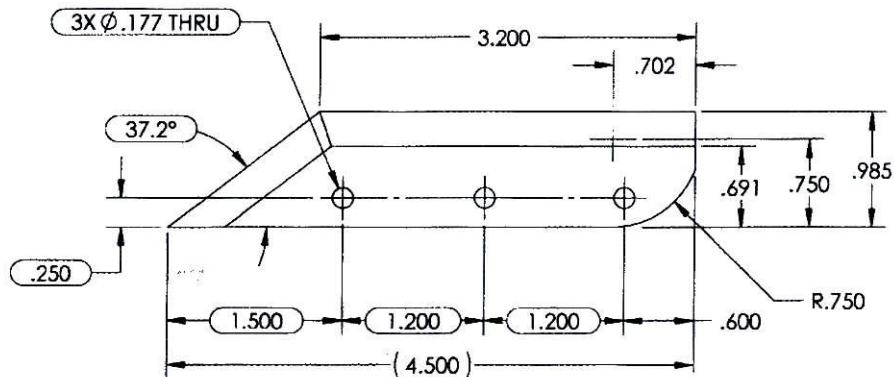
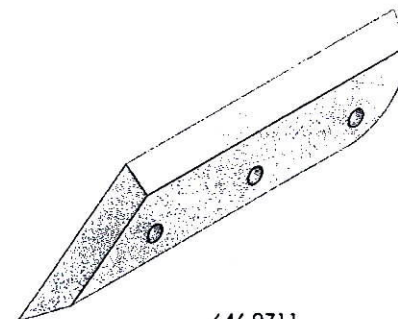
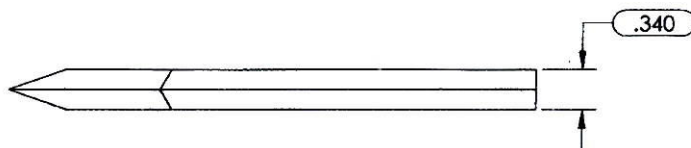


HOLE LOCATIONS $\pm .002$

646.9710

ORIGINAL DATE 10/24/15	REV. 02	DART AEROSPACE APICAL INDUSTRIES, INC. DBA DART AEROSPACE 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300
DRAWN BY R. ROSAND	CHECKED P. BRAYD	
DESIGNED BY P. BRAYD	APPROVED BY P. BRAYD	
CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .001 3 PLACE DECIMALS .0005 ANGLES .5°		SIZE B 07M26 SCALE NONE
PART NO. 646.9700		REV. D SHEET 4 OF 7

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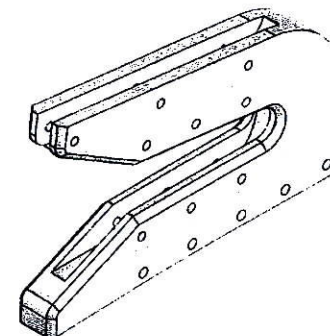
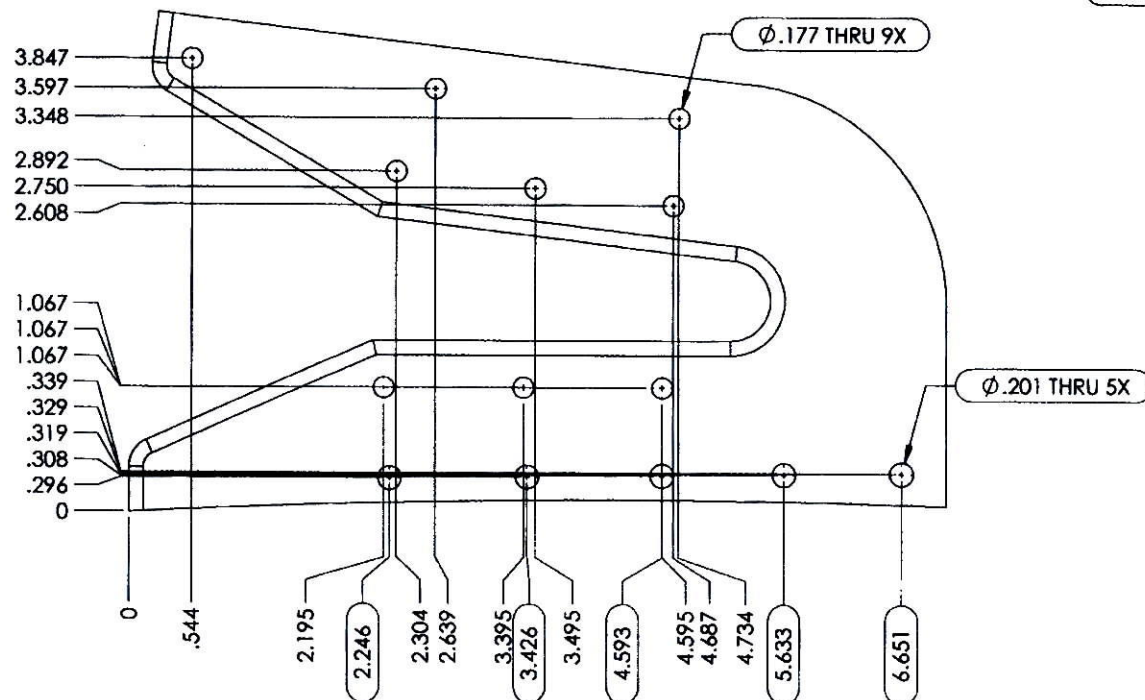


646.9711

ORIGINAL DATE 08-27-09	3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724 5300	
DRAWN BY F. ROSANO	CHECKED BY F. BRAVO	DART AEROSPACE APICAL INDUSTRIES INC. DBA DART AEROSPACE
DRAWING APPROVAL BY DATE		
CONTRACT NO.		CUITER SUB ASSEMBLY 07M26 646.9700 D SCALE NONE SHEET 5 OF 7

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
FRACTIONS DECIMALS 1.01
3 PLACES DECIMALS 0.003
ANGLES ± .5°

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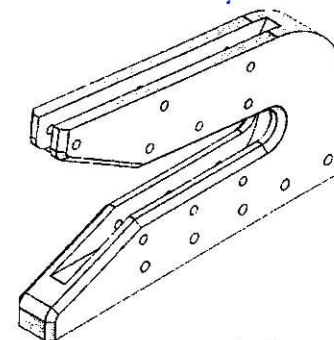


646.9712 9

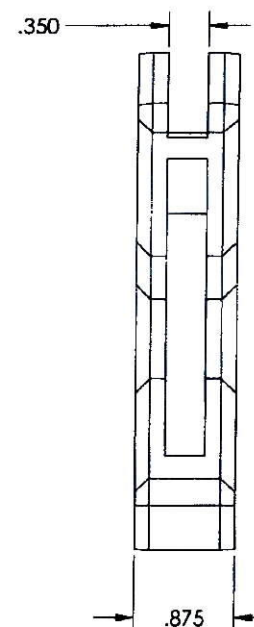
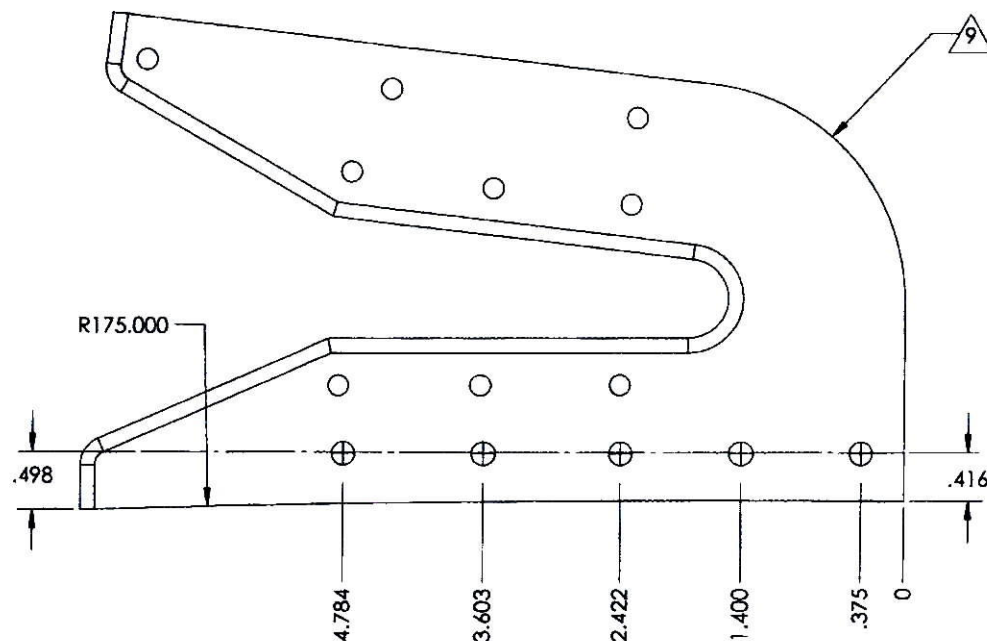
646.9712

ORIGINAL DATE: 06-29-00		DART AEROSPACE 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5300	
DRAWN BY: R. ROSANO		CHECKED BY: P. BRAYO	
DRAWING APPROVAL: P. BRAYO		APICAL INDUSTRIES, INC. DGA DART AEROSPACE	
CONTRACT NO:		CUTTER SUB ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .010 3 PLACE DECIMALS .005 ANGLES $\pm .5^\circ$		REV: 07/02/06	DWG. NO: 646.9700
SCALE: NONE		SHEET: 6 OF 7	

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646.9713



ORIGINAL DATE: 05-21-01		3030 ENTERPRISE CT., SUITE A	
DRAWN BY: CHECKER		VISTA, CA 92081	
A. ROSARIO P. BALVO		(760)-724-5300	
DRAWING APPROVAL:		APICAL INDUSTRIES INC.	
CONTRACT NO.:		DART AEROSPACE	
CUTTER SUB ASSEMBLY			
REV	CAGE CODE	DWG. NO.	REV.
8	07A126	646.9700	D
SCALE: NONE		SHEET 7 OF 7	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038454

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO038454

PO Date: 11/22/17

Due Date: 11/30/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
NOV 27 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

REVISED

Items

Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	165558	646.9711	-	Blade PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED		Firmed	11/30/17	25 pcs	0 pcs	25 pcs	\$2.86666/pcs	\$71.67
2	167185	D5504-1	-	Blade PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED		Firmed	11/30/17	80 pcs	0 pcs	80 pcs	\$2.866666/pcs	\$229.33
3	168538	D5518-1	-	Crossbolt Spacer PO to Metcor: HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061- T6 MATERIAL		Firmed	11/30/17	72 pcs	0 pcs	72 pcs	\$7.375/pcs	\$531.00
4	167204	D5304-1	-	Crossbolt Spacer 1--Issue P/O to Metcore ; P/O HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C		Firmed	11/30/17	16 pcs	0 pcs	16 pcs	\$7.375/pcs	\$118.00

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
323572	1	124140

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
38454		A2	2017/11/24	

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-----------------------	------------------------------	---	-----------------

✓ 105 646.9711
(25) 646.9711
(80) D5504-1

80 D-124.

31,

1 VALISE

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
VALISE	1	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 105

POIDS EXPÉDIÉ / Weight Shipped : 31,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 105

POIDS EXPÉDIÉ / Weight Shipped : 31,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2017/12/04

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
323572	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
38454	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

VAC HARDEN

HARDEN AND TEMPER

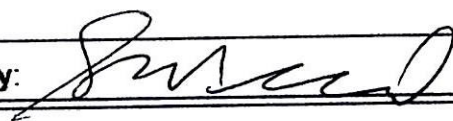
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5	60 - 62 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
105	31	646.9711 (25) 646.9711 (80) D5504-1 1 VALISE

5/11/17

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2017-12-02

APPROUVÉ



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: 646.9711 Revision: Blade														
90	Start up Operation	S009021	165558	0 Ea	0	S009021	Start Up Machining		WIP	11/12/2017	*			
		S009024	165558	0 Ea	0	S009024	Start Up Machining		WIP	11/12/2017	*			
Operation Totals:		2		0	0									
Part Totals:		2		0	0									
Totals:		2		0	0									

Plex 1/8/2018 1:03 PM Dart.Boucher.Sylvie